



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3216-1
Job Sheet 169604



Part No: D3216-1

Job Qty: 36 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/14/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	36 Ea		1/4/18	0.00	0.00	Start Up Waterjet		on 17/12/16
100	Waterjet	36 pcs		1/4/18	0.00	1.85	Waterjet1		on 17/12/16
120	QC	36 pcs		1/4/18	0.00	0.00	QC8		38
130	Small Fab	36 pcs		1/5/18	0.00	5.79	Small Fab-3		38 DAS
140	QC	36 pcs		1/5/18	0.00	0.00	QC5		38
150	Packaging	36 pcs		1/5/18	0.00	0.00	Packaging3	51026	38
160	QC21-SA	36 Ea		1/5/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg D3216
Descriptions: 130 - Tumble until parts have a polished finish.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S11GA	1	91	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	2.600inches ± 0.010	2.610 2.590		
2	Fitting	2.010inches ± 0.010	2.020 2.000		
3	Fitting	0.295inches ± 0.010	0.305 0.285		
4	Fitting	1.548inches ± 0.010	1.558 1.538		
5	Fitting	1.004inches ± 0.010	1.014 0.994		
6	Fitting	0.295inches ± 0.010	0.305 0.285		
7	Fitting	0.250inches ± 0.010	0.260 0.240		
8	Fitting	0.125inches ± 0.010	0.135 0.115		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		The Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com				
Date : _____		Step #: _____						
Description Work Order Deviation								
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:33%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:33%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> </tr> </table>						Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐
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OTHER :								

DART
AEROSPACE
S023584



Fitting

PART NO:
Revision:
Operation:
Change No:

D3216 - 1

Start up Operation

Mfg Date: 12/16/17
 Job No: 169604

Engineering ☐
 Quality ☐
 Other ☐

IB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

DART AEROSPACE LTD		Work Order:	169603
Description: Fitting		Part Number:	D3216-1
Inspection Dwg: D3216 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.600	+/-0.010	2.598	1		V: 0.002	
2.010	+/-0.010	2.013	1			
0.295	+/-0.010	.301	1			
1.548	+/-0.010	1.557	1			
1.004	+/-0.010	1.009	1			
0.295	+/-0.010	.300	1			
0.250	+/-0.010	.245	1			
0.125	+/-0.010	.117	1			

Measured by:	<i>me</i>	Audited by:	<i>JAS</i> 38	Prototype Approval:	N/A
Date:	17/12/16	Date:	DEC 18 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	<i>[Signature]</i>